Work Order ID 73920

Monday, September 19, 2011 11:24:23 AM

Item ID: D2807-041 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Door prop

Start Date: 9/19/2011 **Start Qty:** 25.00 **Cust Item ID:**

Required Date: 9/26/2011 **Req'd Qty:** 25.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** ✓ **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2807	Rev E								
100	PURCHASING	0.00							
Purchasing	**Memo**	0.00							
Purchasing	Issue P/O: 14933 ☐Order as per Dwg D2807☐Possible supplier:Lift Support Technologies,Saskatoon,Canada☐P/N 6/15-164/50-115N ☐ Material release note is required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	**Memo**	0.00							
Packaging	Ensure Material Release Note is attached								
120	QC6- Inspect dimensions to drawing	0.00							
QC	**Memo**	0.00							
Quality Control									

✓ 11-09-19

9/19/26 (25)

counts (25)

Work Order ID 73920

Monday, September 19, 2011 11:24:23 AM

Item ID: D2807-041 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Door prop

Start Date: 9/19/2011 **Start Qty:** 25.00 **Cust Item ID:**

Required Date: 9/26/2011 **Req'd Qty:** 25.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
Small Fab	**Memo**	0.00							
Small Fab	1-install D3671-1 as per dwg D2807								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
150	Identify as per dwg & Stock Location ST22	0.00							
Packaging	**Memo**	0.00							
Packaging									

11/09/28 25

counts +25

25K SP 11-09-28

Work Order ID 73920

Monday, September 19, 2011 11:24:23 AM

Item ID: D2807-041
Revision ID:
Item Name: Door prop
Start Date: 9/19/2011 **Start Qty:** 25.00
Required Date: 9/26/2011 **Req'd Qty:** 25.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							11/10/3
QC	**Memo**	0.00							MK 11-09-28
Quality Control									

Picklist Print

Monday, September 19, 2011 11:24:20 AM

Work Order ID: 73920

Parent Item: D2807-041

Parent Item Name: Door prop

Start Date: 9/19/2011 **Required Date:** 9/26/2011

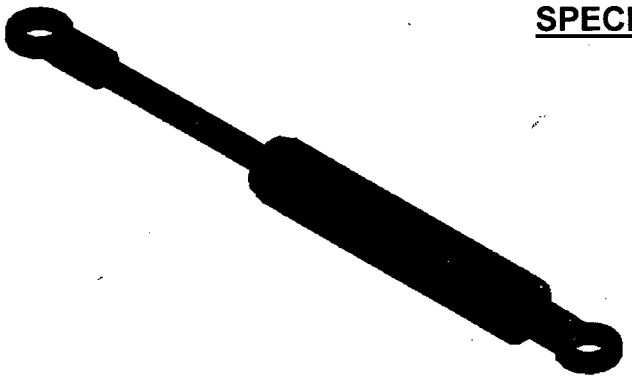
Start Qty: 25.00 **Required Qty:** 25.00

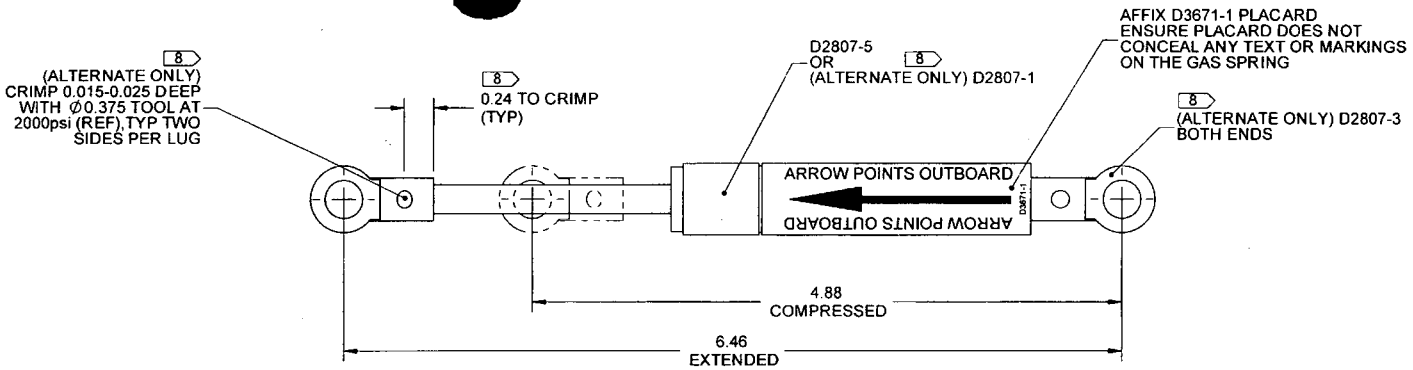
Comments: IPP: D□ 07.11.12 ecn1019, replaces D2807□ EC□verified by DD
IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
6/15-164/50-115N Gas Spring		Purchased	No			130	Each	0.0000	1	25			
D3671-1 Placard		Manufactured	No			110	Each	16.0000	1	25			

Location	Loc Qty	Loc Code
GA	16	
73033	16	

SPECIFICATION CONTROL DRAWING





D2807-041 GAS SPRING

RELEASED

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

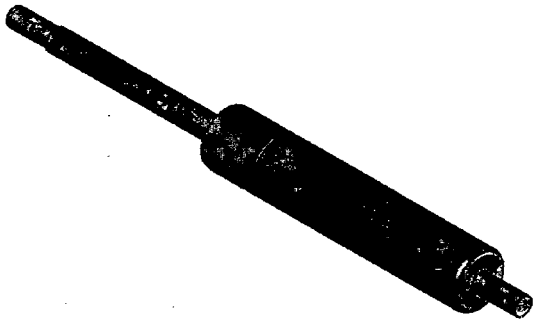
w/673920

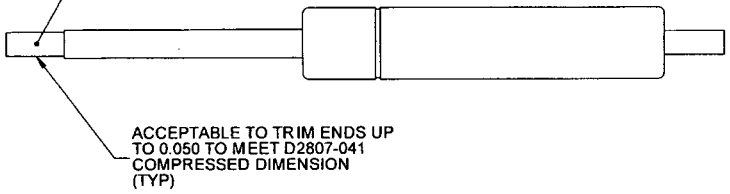
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 0.169 LBS
8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2) (WEIGHT: 0.176 LBS) △E

REV.	DESCRIPTION	BY	DATE
E	ADD D2807-5 GAS SPRING; D2807-1/-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03

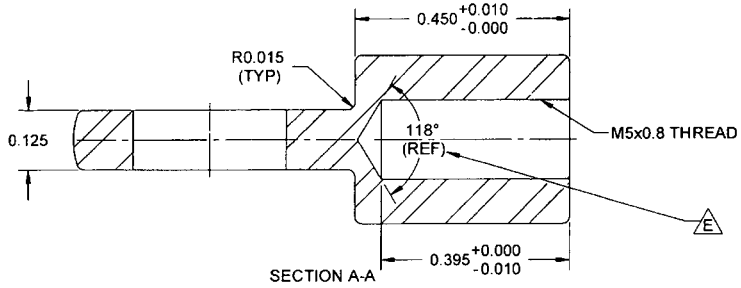
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. E
MFG. APPR.		D2807 SHEET 1 OF 3
APPROVED		TITLE SCALE
DE APPR.		GAS SPRING NTS
DATE	07.12.28	

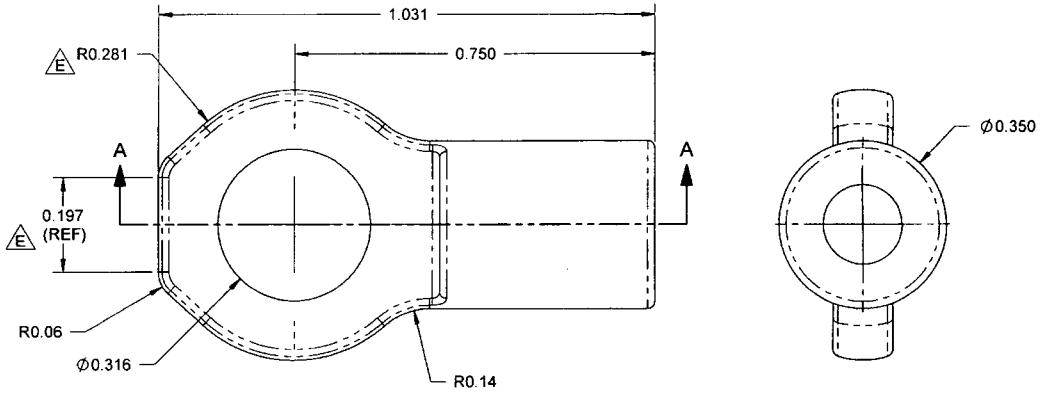
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D2807-1 GAS SPRING
SCALE 1:1





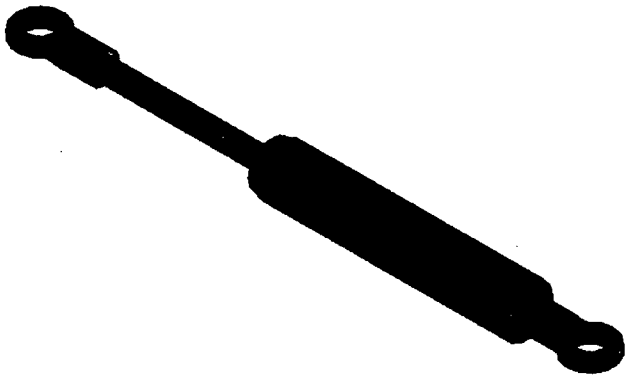
D2807-3 LUG

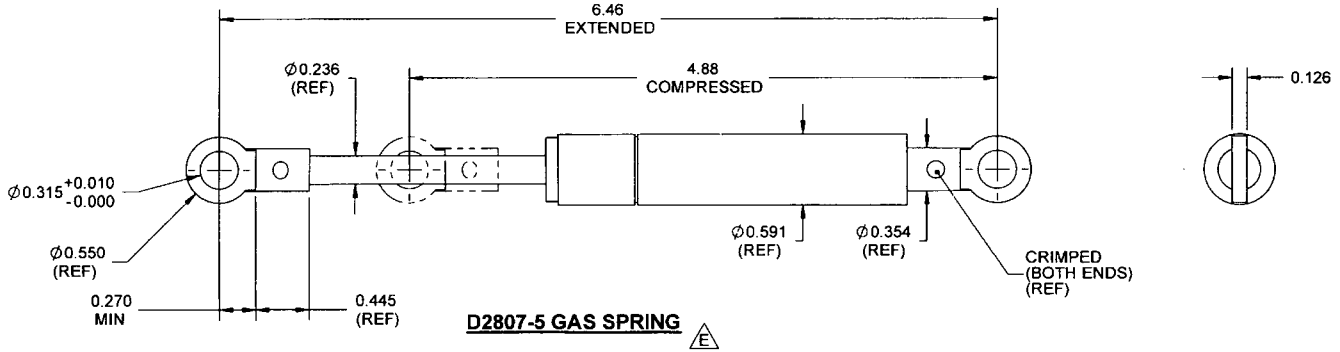
D2807-1 GAS SPRING NOTES:
1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXF6S6050080S6L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 0.144 LBS
8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS

D2807-3 LUG NOTES:
1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.010 TO 0.015
6) IDENTIFICATION: N/A
7) WEIGHT: 0.016 LBS

DESIGN		**DART AEROSPACE LTD**	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2807	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GAS SPRING	4:1
DATE	07.12.28		

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D2807-5 GAS SPRING (E)

D2807-5 GAS SPRING NOTES:
1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA
(P/N 6/15-164/50-115N)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 0.169 LBS
8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS,
ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	PH	
CHECKED		DRAWING NO. D2807 REV. E SHEET 3 OF 3
MFG. APPR.		
APPROVED		TITLE GAS SPRING SCALE 4:1
DE APPR.		
DATE	07.12.28	

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO14933

Purchase Order Date 9/19/2011
PO Print Date 9/19/2011

Order From : VC-LST0001

LS TECHNOLOGIES INC.
303-103 STREET
SASKATOON, SK S7N 1Y9
CA

Contact Name		**Buyer**	Linda Lacelle
Vendor Phone	306 683 5000	**Requisition Nbr**	
Vendor Fax	306 683 6403	**Tax Resale Nbr**	10127-2607
Vendor Account Nbr		**Terms**	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference / Revision ID / Vendor Part Number	Description / Mfg ID	Req Date / Taxable	Req Qty / Unit of Measure	Ship Method	Unit Price	Extended Price
1	6/15-164/50-115N	Gas Spring	9/23/2011 Yes	25.00 Each	FedEx PI collect	$63.9000	$1,597.50

Special Inst: PER DRWG D2807 REV.E

PO Total: $1,597.50

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required when applicable

Change Nbr: 1 **Change Date:** 9/19/2011

LS Technologies Canada Inc.

303 - 103 Street
Saskatoon, SK Canada
S7N 1Y9

Packing Slip

Date	Invoice #
9/19/2011	7709

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

P.O. No.	Ship	Via	FOB	Project
14933	9/19/2011	Fed-Ex		

Qty	Description
25	D2807 Stainless Gas Spring (6/15-164/50-115N)
	Shipping Via FED EX Tracking # 576900015000638

8 11/04/26

Lift Support Technologies

303 – 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

Sept 19, 2011

This is to certify that the parts listed below meets specifications as required by your order.

25 Units: D2807 Stainless Gas Spring (6/15-164/50-115N)

Country of Manufacture : Canada
Date of Manufacture : August, 2011
This product is ROHS compliant.

Purchase Order # 14933

L S Technologies Inc Canada

Nolan Fehr
President